

Work Order ID 78628

78628

Page 1

January-11-12 2:53:02 PM

Item ID: D3245-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel
 Start Date: 11/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3245	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 B12-3-5
 FLOW CNC Waterjet I-Cut as per Dwg D3245 ****prog.D3245-1/-2**** Dwg
304.032 Rev: B Prog Rev: B 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 B12-3-5
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 8/17/13/05
 Quality Control (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary C'sink as per Dwg D3245 Form D3245-1 as per Dwg D3245 Identify as D3245-1	0.00 0.00							
---	---	--------------	--	--	--	--	--	--	--

B 12/03/04 *12/04/03* *12*

140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
--	---	--------------	--	--	--	--	--	--	--

8/26/03 *12*

150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>St 232</i> Memo	0.00 0.00							
---	---	--------------	--	--	--	--	--	--	--

12/04/04 *12*

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Accept

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Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 11/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML 5 12/04/04

12-04-04

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Picklist Print

January-11-12 2:53:05 PM

Page 1

Work Order ID: 78628

78628

Parent Item: D3245-2

D3245-2

Parent Item Name: Panel

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A04.07.07New issueKJ/JLM

IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA

Purchased

No

100

sf

60.3600

0.804

10.15579

M304S22GA

B12-3-5

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

60.36

109057

3.3

117379

7.06

118271

47.5

118400

2.5

120866

120866

12

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DART AEROSPACE LTD		Work Order: 78628
Description: Doubler		Part Number: D3245-2
Inspection Dwg: D3245	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	✓		V IBZ	
Ø0.375	+0.006/-0.001	.374	✓		V	
0.400	+/-0.010	.397	✓		V	
1.117	+/-0.010	1.116	✓		V	
1.150	+/-0.010	1.152	✓		V	
1.000	+/-0.010	1.001	✓		V	
10.57	+/-0.030	10.571	✓		P AB	
9.500	+/-0.010	9.506	✓		P ROWSKY	
8.350	+/-0.010	8.344	✓		P	
3.500	+/-0.010	3.501	✓			
9.40	+/-0.030	9.402	✓		P	
11.04	+/-0.030	11.045	✓		P	
6.200	+/-0.010	6.200	✓		V	
2.230	+/-0.010	2.234	✓		V	
2.020	+/-0.010	2.021	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 12-3-7	Date: 12/03/05	Date:	N/A
Rev	Date	Change	Revised by
A	08.09.04	New Issue	KJ/DD
			Approved
			DD

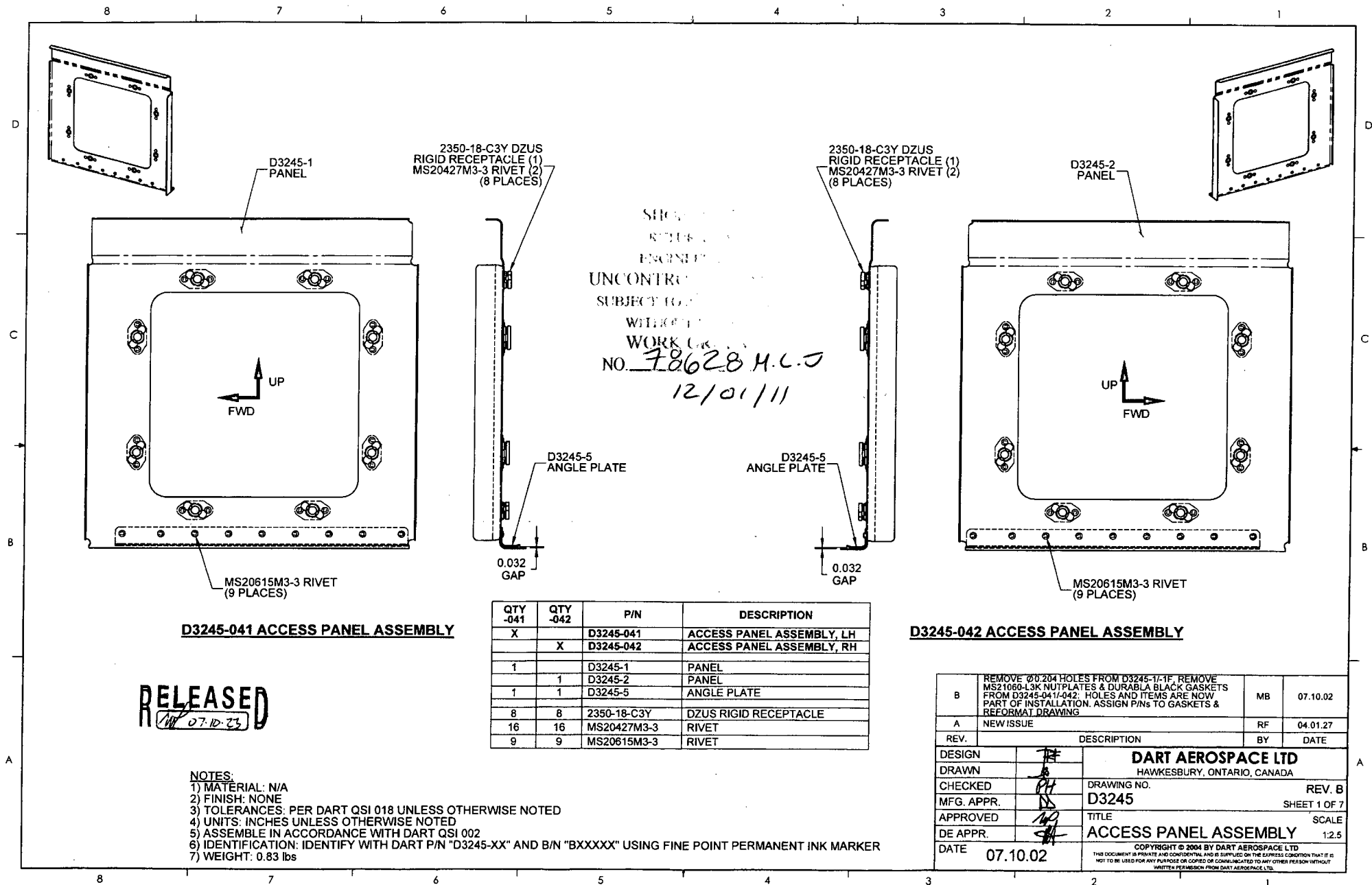
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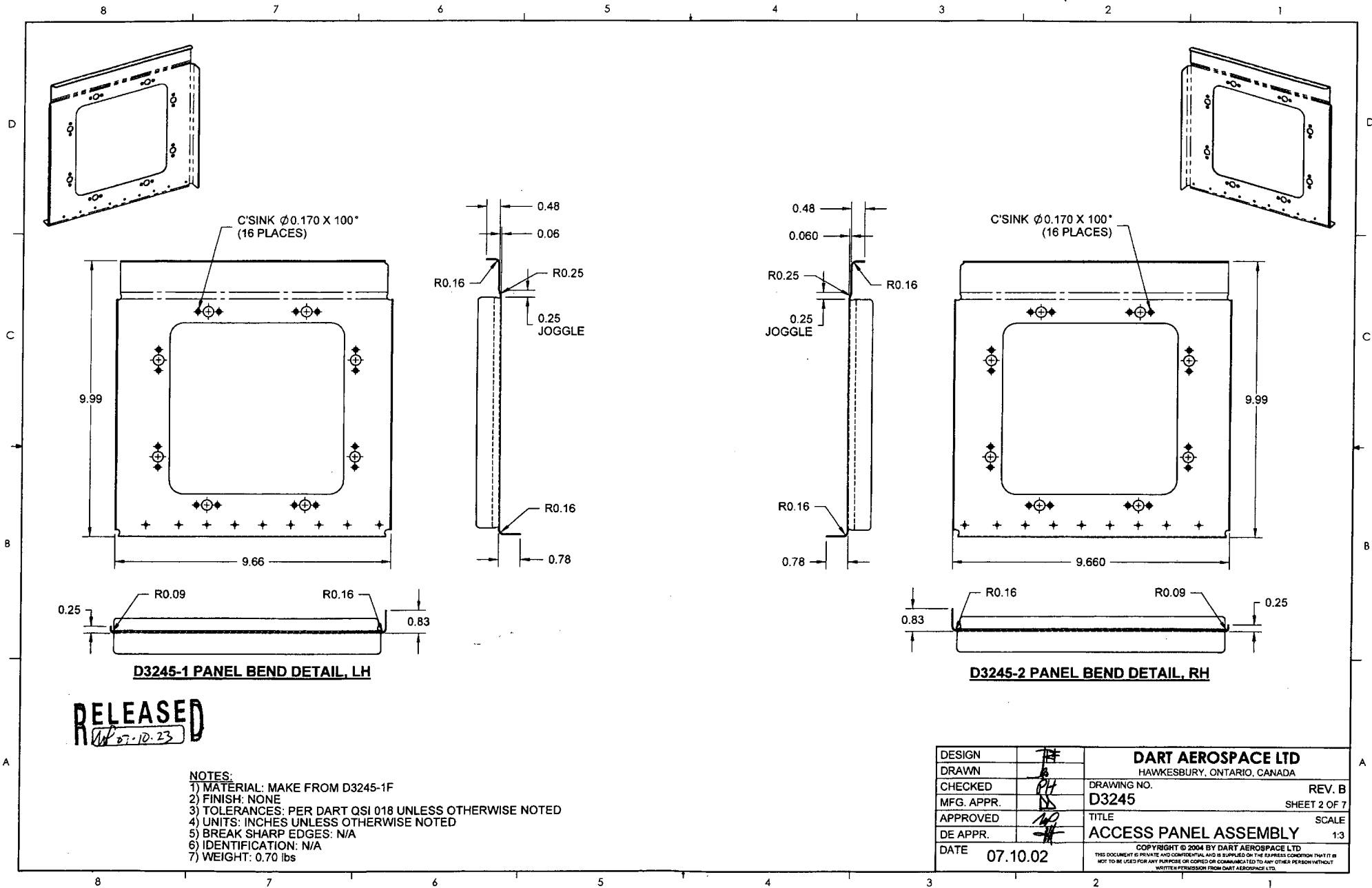
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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RELEASED
11/27/10-23

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	1:3
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D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET
(REF)

8.00
(TYP, REF)

INSTALL D3245-7
GASKET ON THIS SIDE

D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

DESIGN	JH	DART AEROSPACE LTD	
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CHECKED	JH	DRAWING NO.	REV. B
MFG. APPR.	JH	D3245	SHEET 3 OF 7
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RELEASED
AMP 07.10.03

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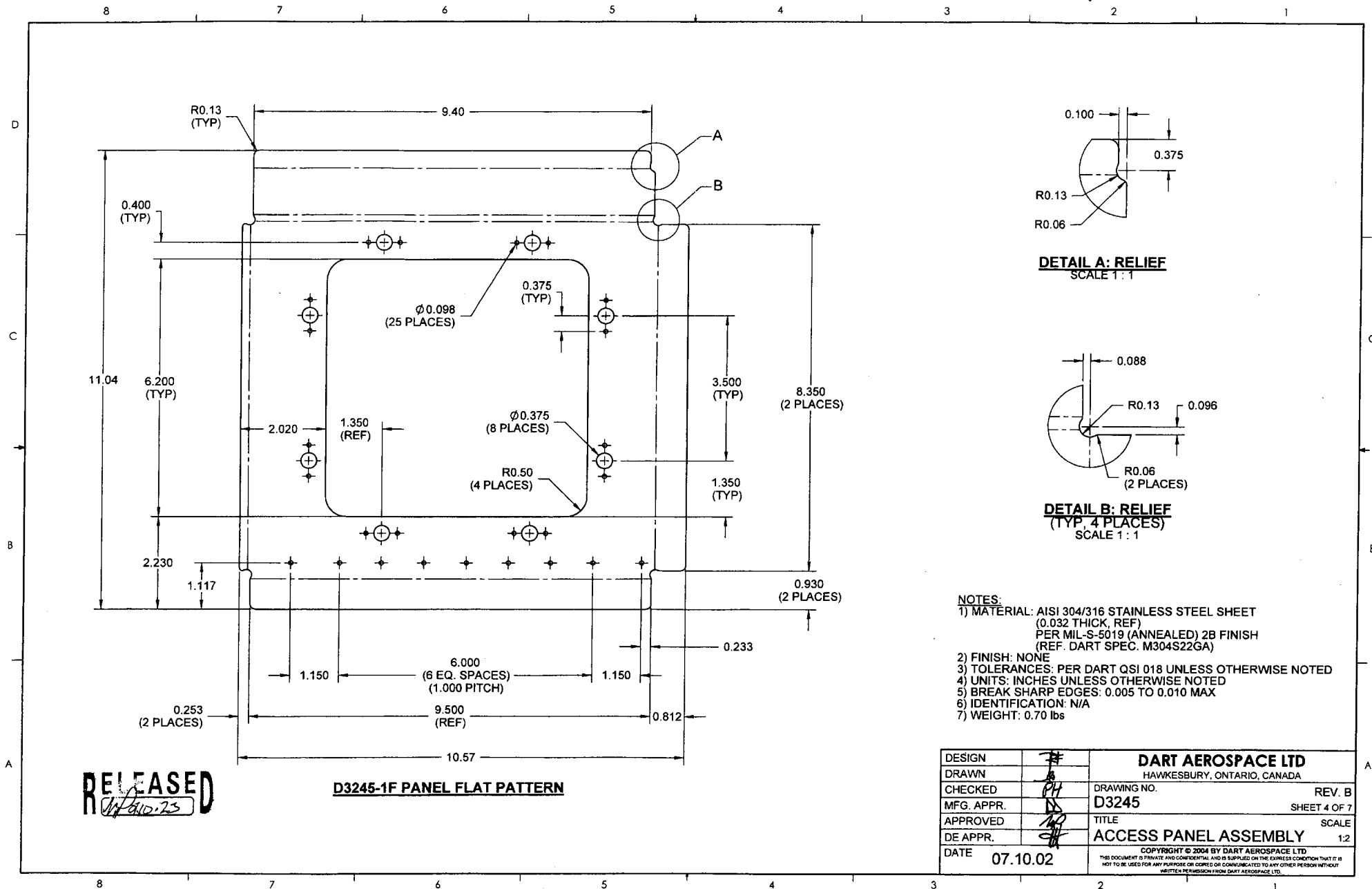
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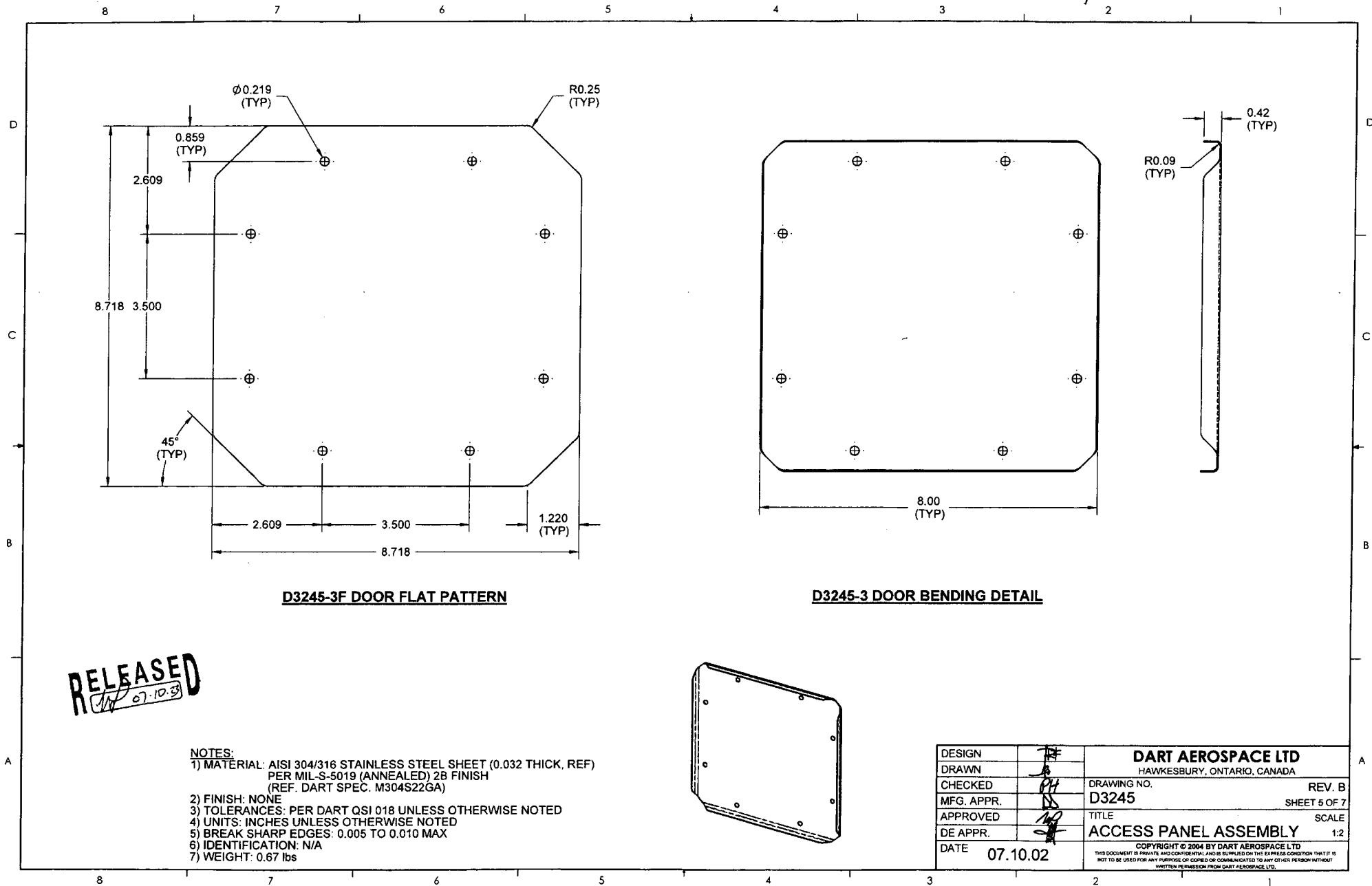
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D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

RELEASED
07-10-02

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.67 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 5 OF 7
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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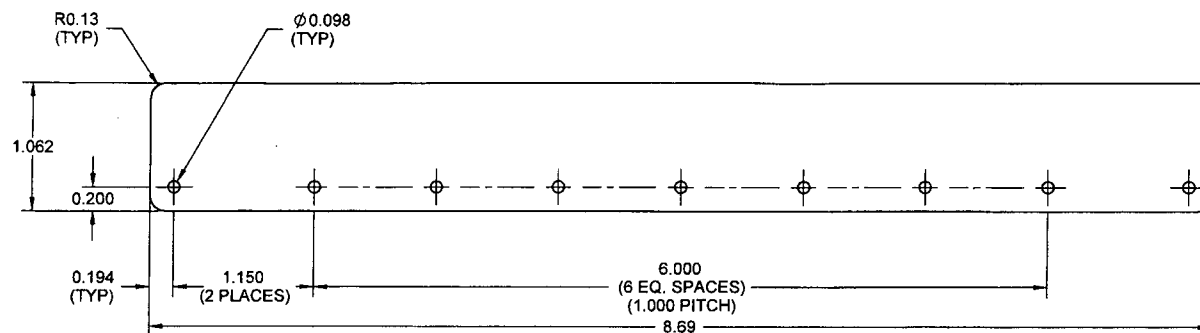
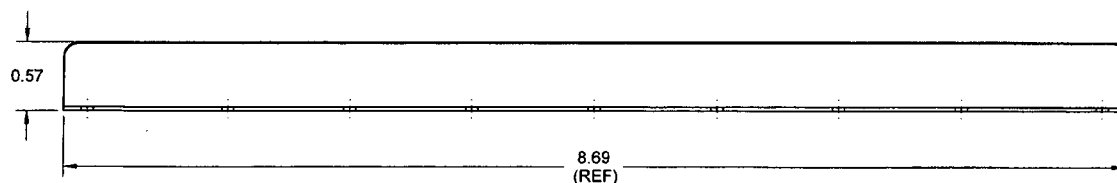
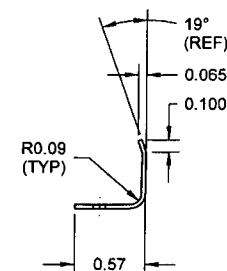
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8 7 6 5 4 3 2 1

D

D

**D3245-5F FLAT PATTERN****D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)**RELEASED
07.10.13**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	PH	DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

A

A

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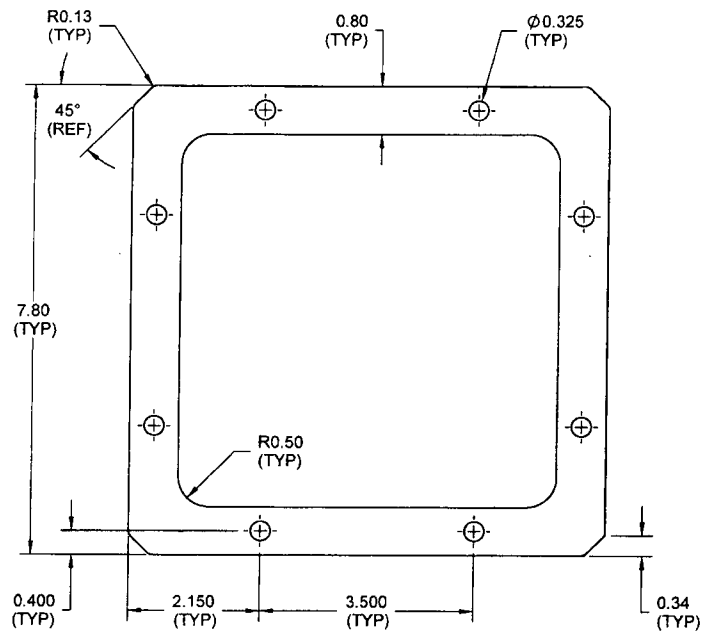
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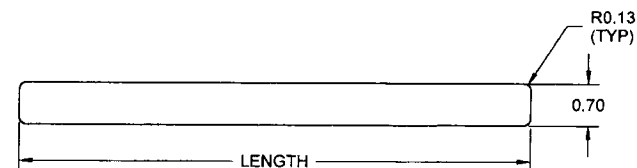
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3245	REV. B
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